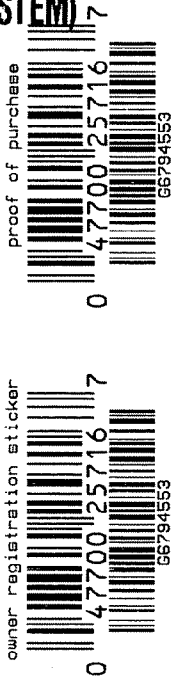


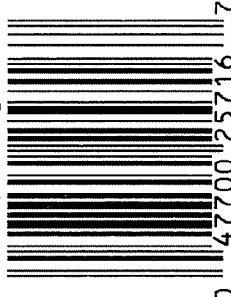
G6794553

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

BM FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6
G6794553	
UPC 	

GUN SERIAL #

G 6794553

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-30-08	SPD
430	ASSEMBLE TO STOCK		9-30-08	SP
440	PROOF		9-30-08	SPD
460	CHECK HEADSPACE		9-30-08	SPD
470	DIS-ASSEMBLE ACTION		9-30-08	SPD
472	SERIALIZE BOLT HANDLE	MAGNA-FLUX	10-1-08	RSN
475	DRILL AND TAP SIGHT HOLES	90° 200c	10-1-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (B)	10/1/08	(B)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/2/08	RT
520	GOFF BLAST BBL / REC		10/3/08	26
542	APPLY COATINGS (BARREL ACTION)		10-8	✓
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-9-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-9-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-9-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-28-08	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		
F004 REV 5/2006				

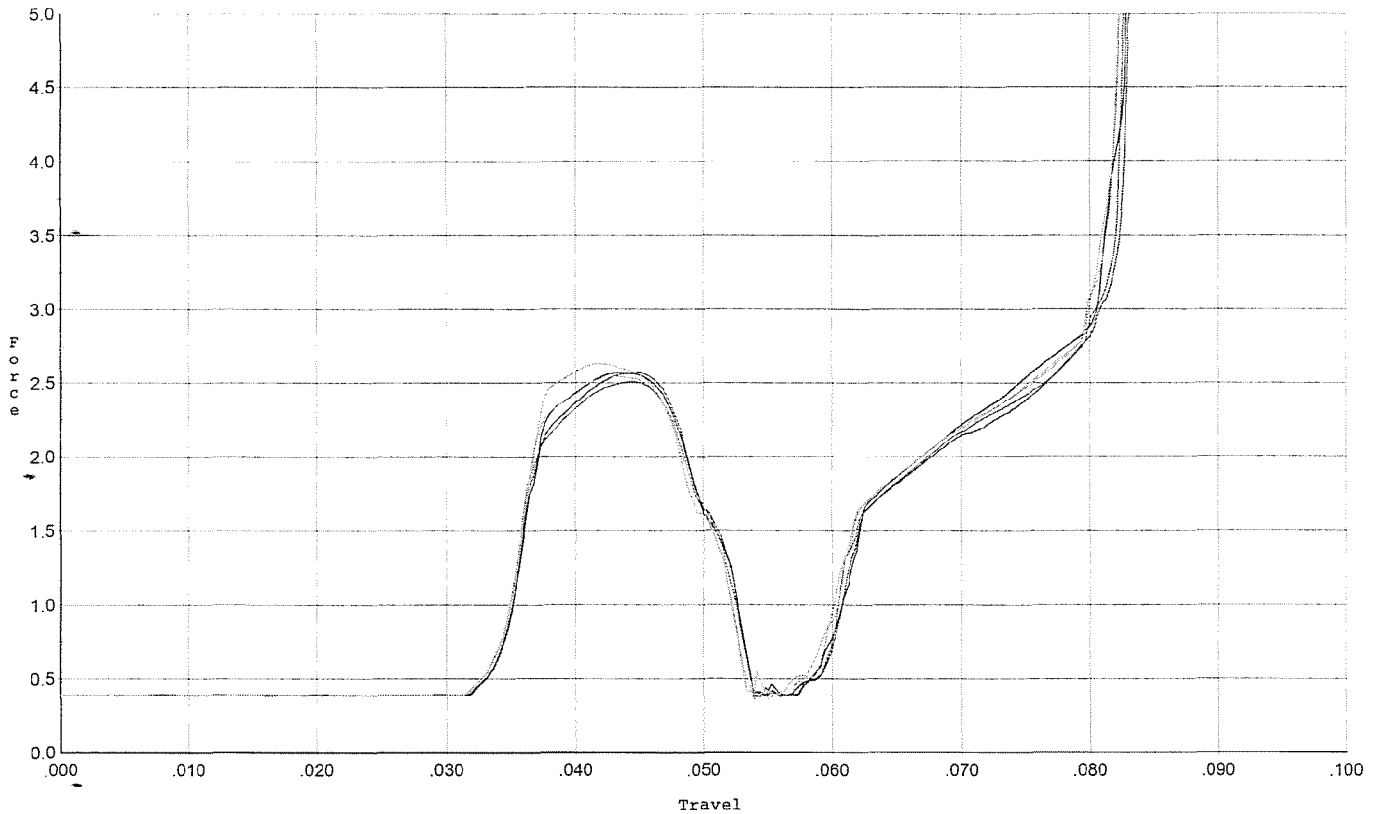
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	10-30-08	LH
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>4.0</u> <u>5.0</u>	10-30-08	LH, JH
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	10-30-08	LH, JH
	J) ASSEMBLE STOCK		10-28-08	LH, JH
	K) ASSEMBLE SWIVEL STUDS		10-30-08	LH, JH
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	10-29-08	LH, JH
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-27-08 TAE	TAE
670	FINAL INSPECTION A) HEADSPACE		10-30-08	LH, JH
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.76</u> <u>2.80</u> <u>2.78</u> <u>2.89</u> <u>2.85</u>	10-30-08	LH, JH
	C) FUNCTION		10-30-08	LH, JH
690	PACK		10/31/08	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 8/21/08

Model: M/24
 Serial No: Form #F005
 Trigger: 2.5 lbs. ini. +/- .50 lbs.

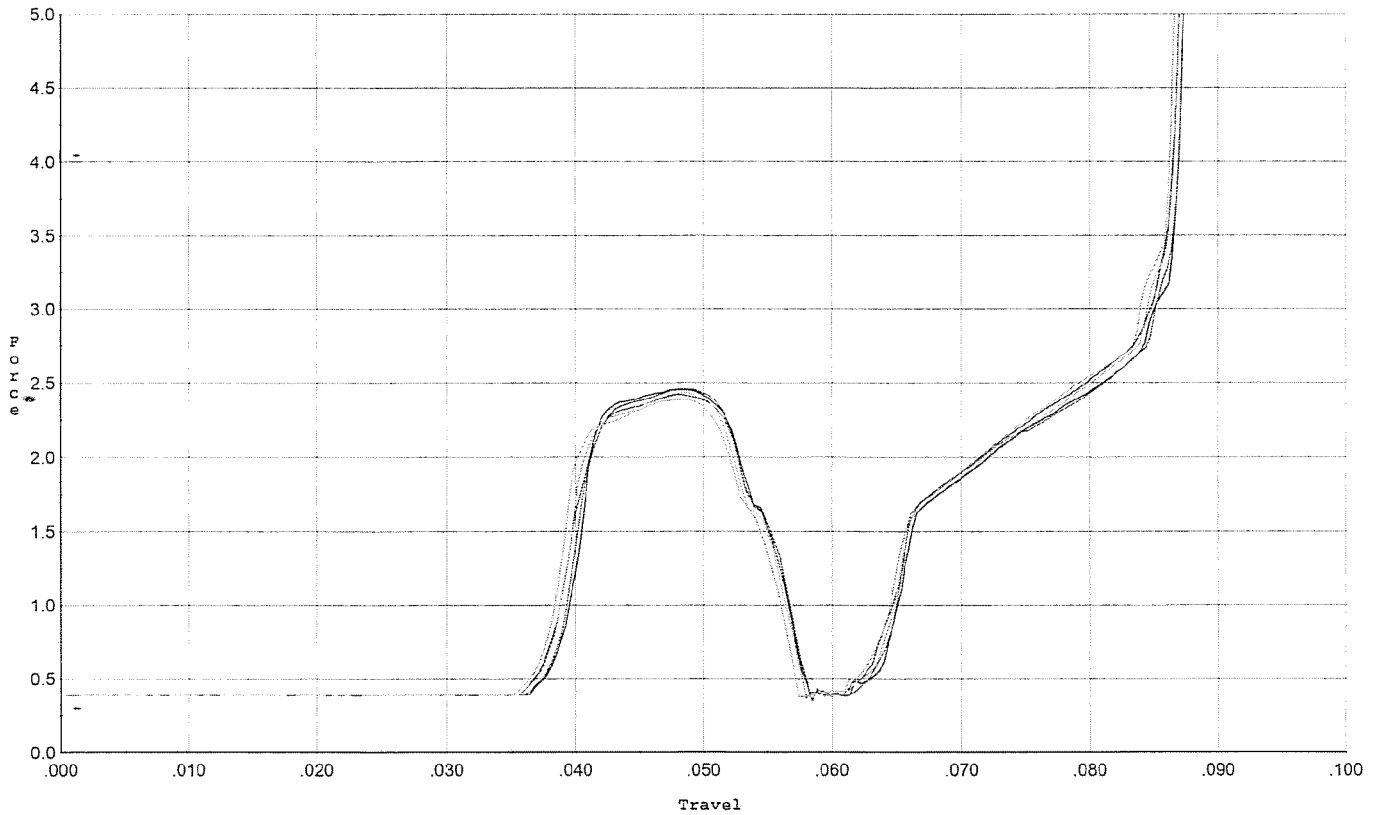


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.572	0.052	0.034	0.036	0.050		Set Trigger
2	2.568	0.052	0.034	0.036	0.051		Set Trigger
3	2.508	0.052	0.034	0.036	0.050		Set Trigger
4	2.544	0.052	0.034	0.036	0.050		Set Trigger
5	2.627	0.052	0.034	0.036	0.051		Set Trigger

Aug 2.56

Trigger Profile [lbs,inch]

Profile:	SWS	Model:	M/24
GunType:	Rifle	Serial No:	Form #F005
Make:	Remington	Trigger:	2.5 lbs. after 50 cycles +/- .50 lbs.
Note:	R. Putch 8/21/08		



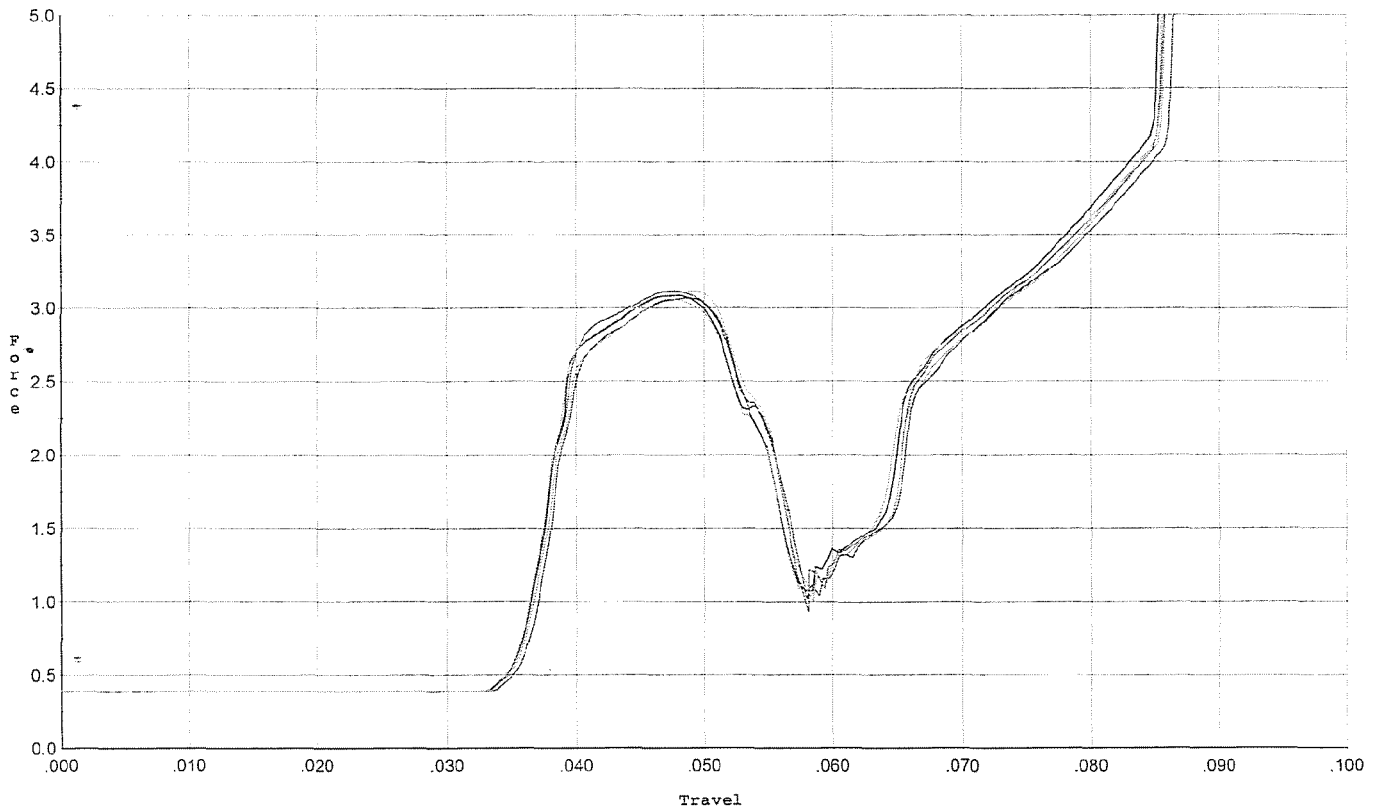
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.458	0.056	0.038	0.038	0.052		Set Trigger
2	2.454	0.056	0.038	0.038	0.051		Set Trigger
3	2.419	0.056	0.038	0.038	0.051		Set Trigger
4	2.431	0.057	0.038	0.038	0.052		Set Trigger
5	2.390	0.056	0.037	0.037	0.051		Set Trigger

Aug 243

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/21/08

Model: M/24
Serial No: Form #F005
Trigger: 3.0 lbs. ini. +/- .75 lbs.



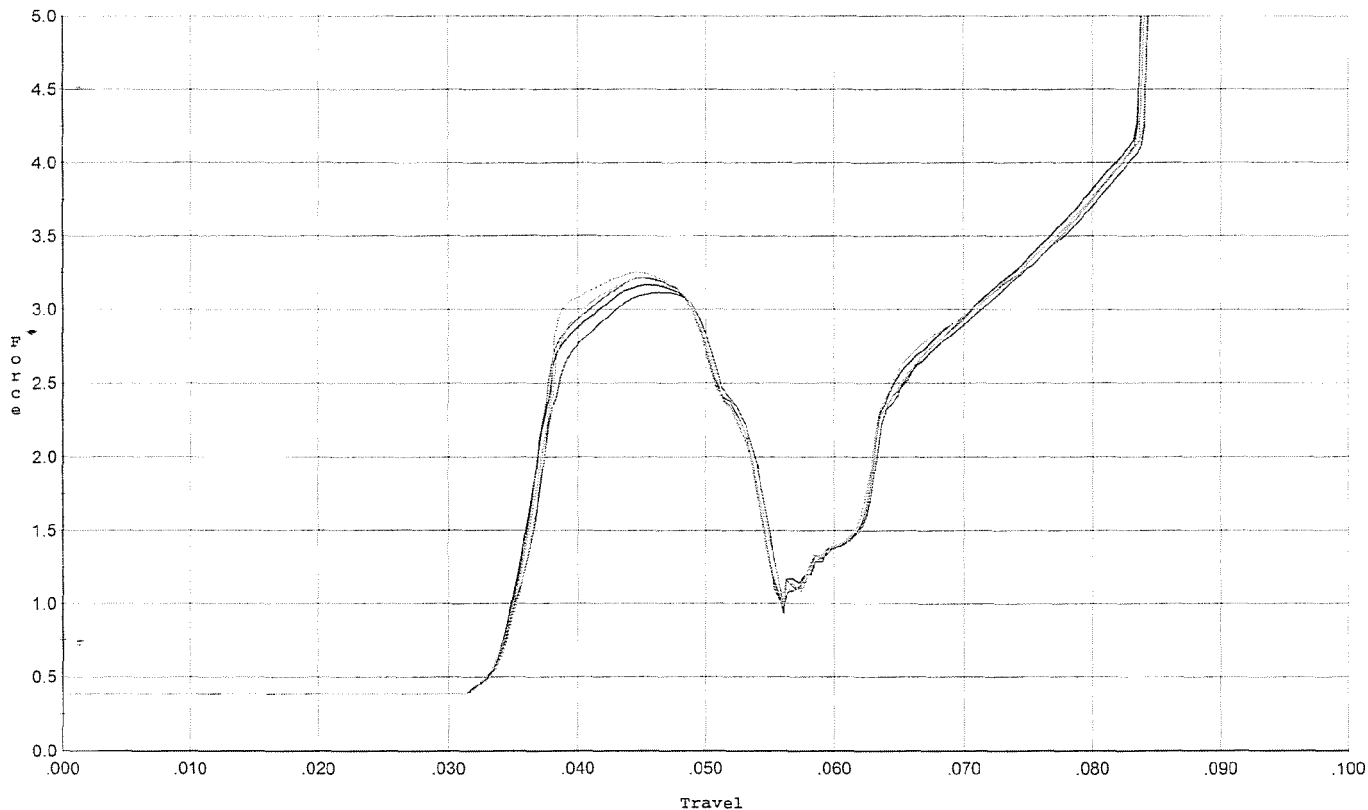
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.065	0.057	0.036	0.036	0.065		Set Trigger
2	3.082	0.055	0.035	0.036	0.064		Set Trigger
3	3.113	0.055	0.035	0.036	0.065		Set Trigger
4	3.065	0.055	0.035	0.036	0.064		Set Trigger
5	3.115	0.055	0.036	0.036	0.064		Set Trigger

Avg. 3.08

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/21/08

Model: M/24
Serial No: Form #F005
Trigger: 3.0 lbs. after 20 cycles +/- .75 lbs.



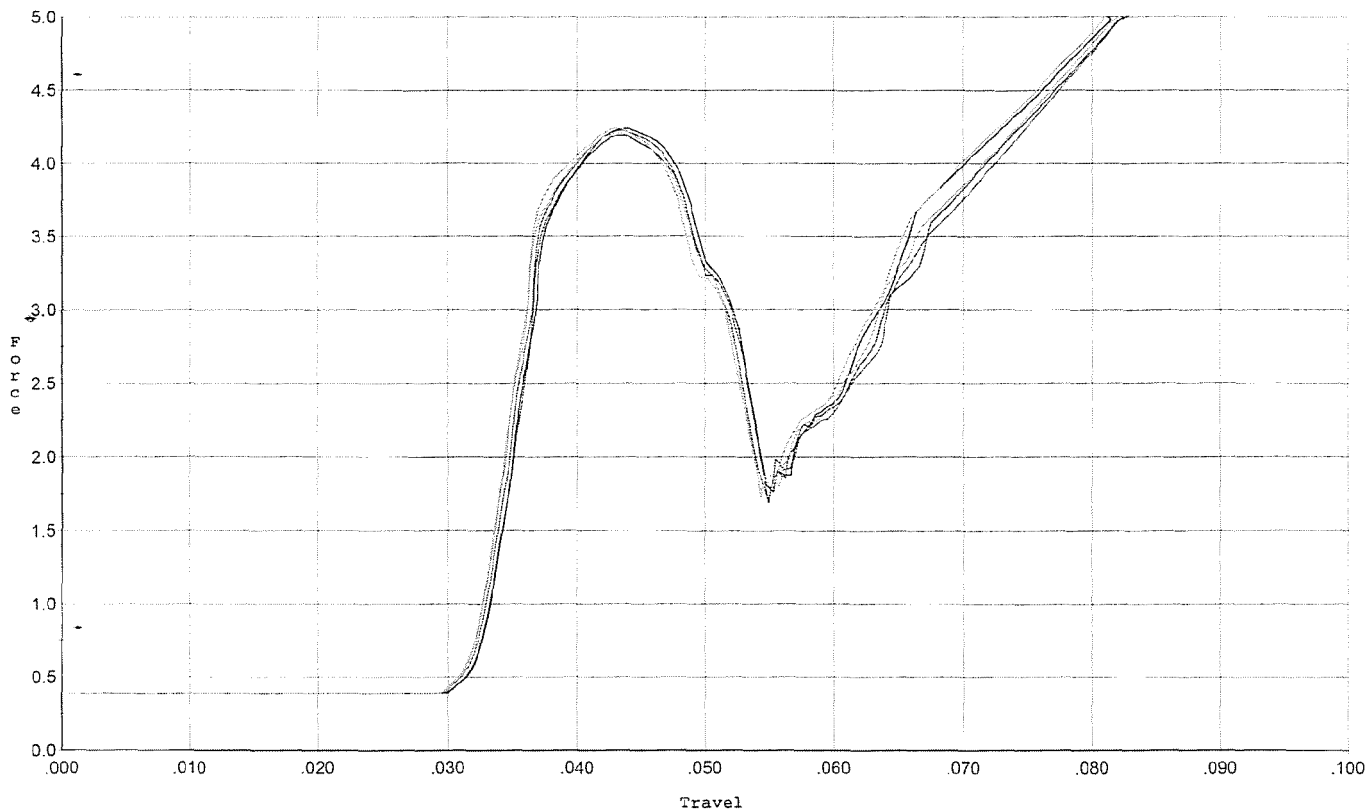
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.112	0.054	0.034	0.035	0.064		Set Trigger
2	3.165	0.053	0.034	0.035	0.064		Set Trigger
3	3.215	0.053	0.034	0.035	0.064		Set Trigger
4	3.209	0.053	0.034	0.036	0.064		Set Trigger
5	3.253	0.053	0.034	0.035	0.065		Set Trigger

Aug-3.19

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/21/08

Model: M/24
 Serial No: Form #F005
 Trigger: 4.0 lbs. ini. +/- 1.0 lbs.



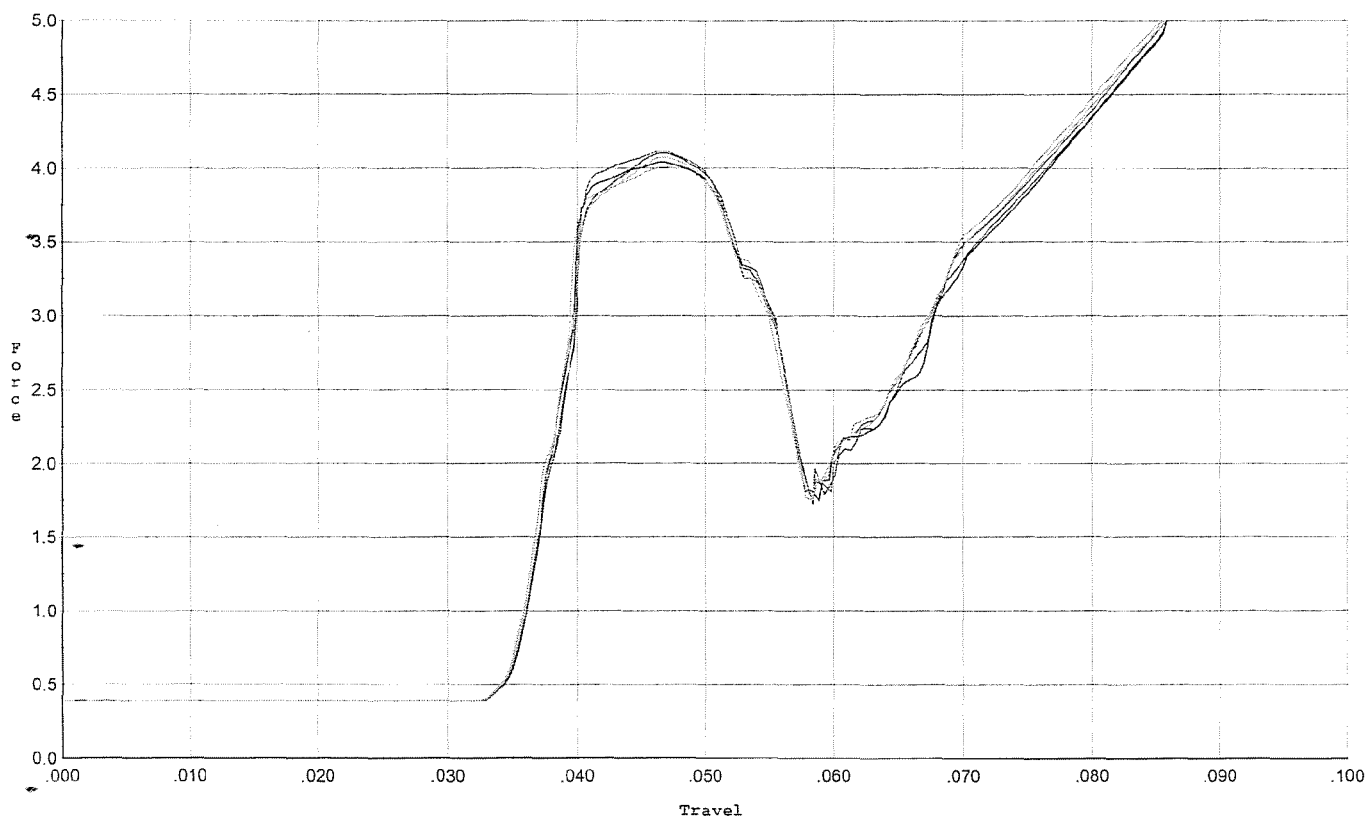
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.194	0.053	0.032	0.033	0.081		Set Trigger
2	4.239	0.053	0.032	0.033	0.082		Set Trigger
3	4.226	0.052	0.032	0.034	0.081		Set Trigger
4	4.209	0.052	0.032	0.033	0.082		Set Trigger
5	4.243	0.053	0.032	0.033	0.082		Set Trigger

Aug 4.22

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/21/08

Model: M/24
 Serial No: Form #F005
 Trigger: 4.0 lbs. after 20 cycles +/- 1.0 lbs.

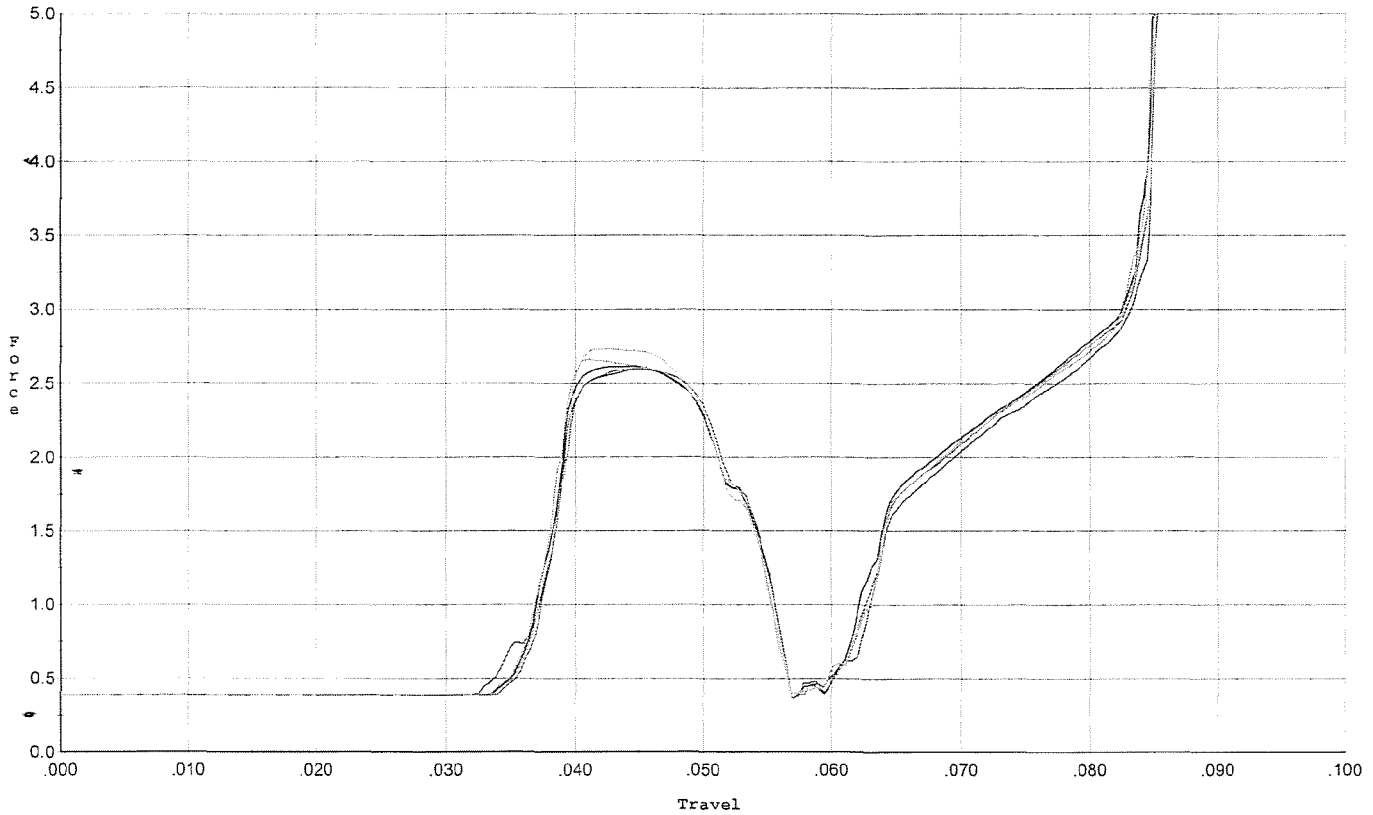


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.103	0.055	0.035	0.035	0.082		Set Trigger
2	4.039	0.056	0.035	0.035	0.082		Set Trigger
3	4.117	0.056	0.035	0.035	0.082		Set Trigger
4	4.006	0.056	0.035	0.034	0.083		Set Trigger
5	4.075	0.056	0.035	0.034	0.082		Set Trigger

Avg 4.06

Trigger Profile [lbs,inch]

Profile	SWS	Model:	M/24
GunType:	Rifle	Serial No:	Form #F005
Make:	Remington	Trigger:	reset to 2.5 lbs. +/- .50 lbs. for final test
Note:	R. Putch 10/21/08		



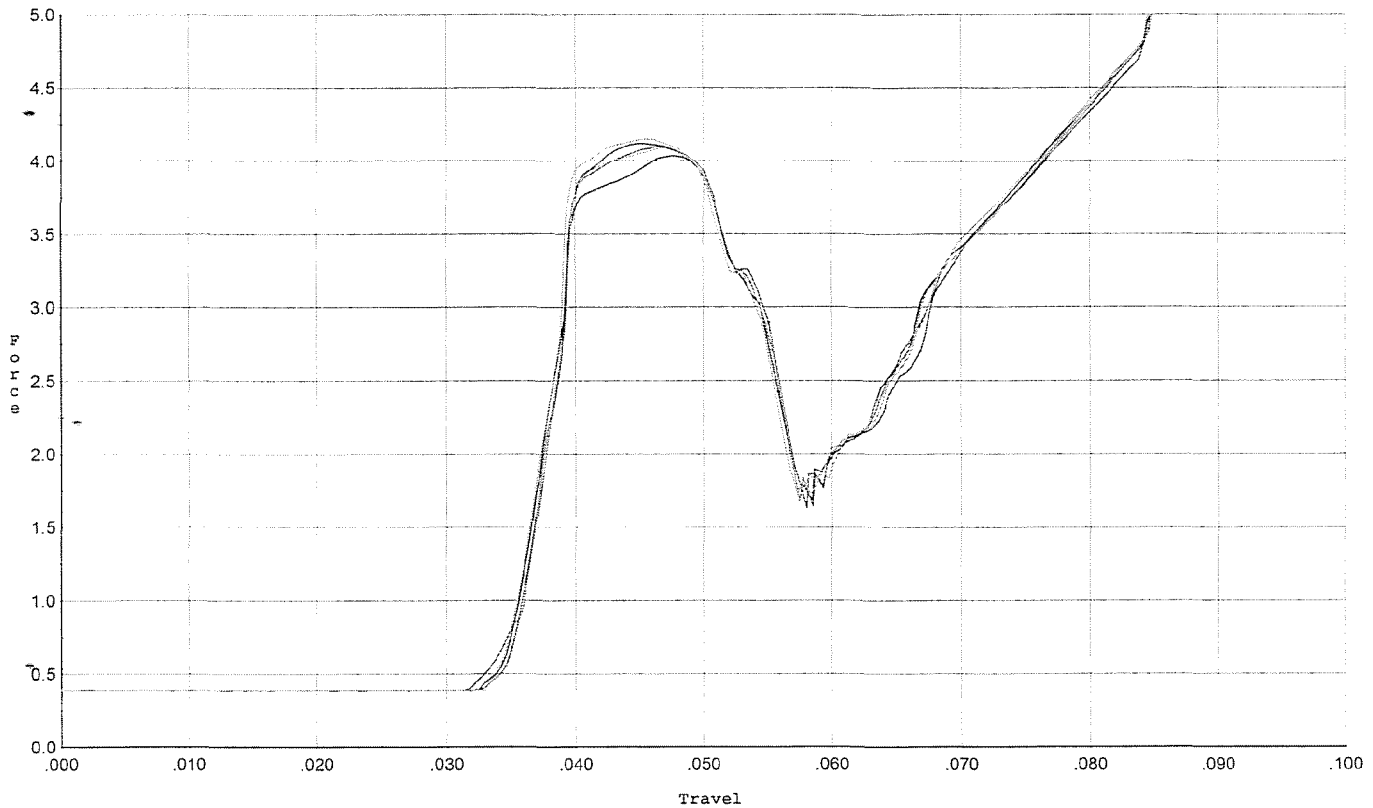
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.598	0.055	0.035	0.037	0.054		Set Trigger
2	2.614	0.054	0.036	0.037	0.053		Set Trigger
3	2.596	0.055	0.036	0.037	0.054		Set Trigger
4	2.735	0.054	0.036	0.037	0.054		Set Trigger
5	2.663	0.054	0.036	0.037	0.054		Set Trigger

Aug 2.64

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/21/08

Model: M/24
 Serial No: Form #F005
 Trigger: set to 4.0 lbs. +/- 1.0 lbs.



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.118	0.055	0.034	0.034	0.082		Set Trigger
2	4.032	0.056	0.035	0.034	0.082		Set Trigger
3	4.097	0.055	0.035	0.034	0.082		Set Trigger
4	4.146	0.055	0.034	0.035	0.082		Set Trigger
5	4.087	0.055	0.035	0.035	0.081		Set Trigger

Avg 4.09